

Work Order ID 110834

Thursday, January 23, 2014 12:03:52 PM

110834

Page 1

Item ID: D2230-1

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Mounting Lug

Start Date: 1/7/2014 Start Qty: 200.00

200

Cust Item ID:

Required Date: 2/21/2014 Req'd Qty: 200.00

200

Customer:

Reference:

Approvals:

Process Plan: CL

Date: 1/10/23

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2230

Rev G

110

Outsource process - Machining

0.00

110

HAAS CNC VERTICAL MACHINING #1

Outsource5

Memo

0.00

Outsource process - Machining

Issue P/O to Metec: P022759

Machine as per dwg

C of C is required

July 14/1/23

120

Receive & Inspect for Damage & Mat'l Certs

0.00

120

Packaging

Memo

0.00

Packaging

Ensure C of C is attach

1/14/23 (80)

130

QC6- Inspect dimensions to drawing

0.00

130

QC

Memo

0.00

Quality Control

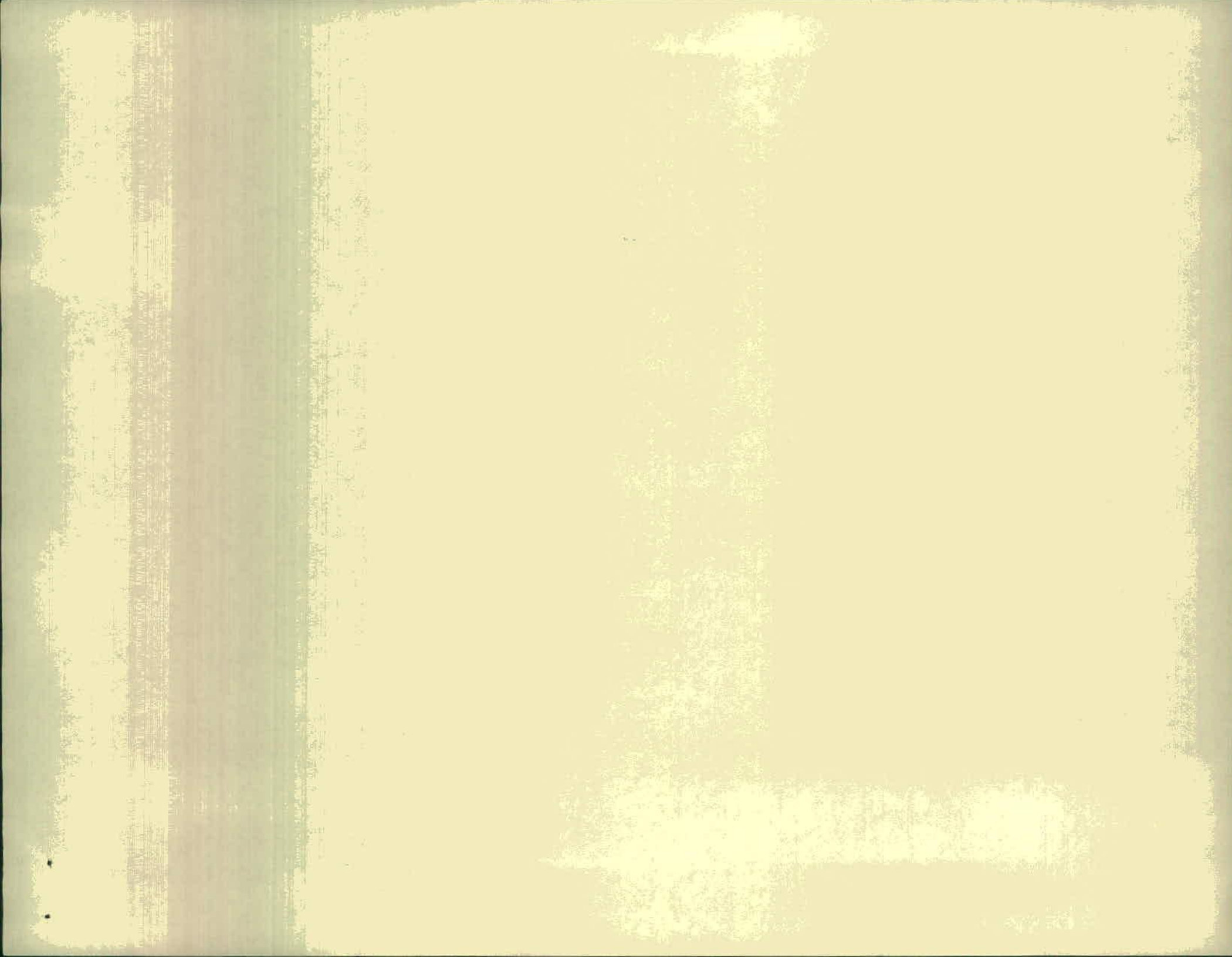
DAS

27

9-89

4/3/3

80



Work Order ID 110834

Thursday, January 23, 2014 12:03:52 PM

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Page 2

Item ID: D2230-1 Accept ***N9000040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mounting Lug
Start Date: 1/7/2014 Start Qty: 200.00 ***200*** Cust Item ID:
Required Date: 2/21/2014 Req'd Qty: 200.00 ***200*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 <i>Memo</i>	0.00 0.00	<i>chemical @ ATG</i>			<i>CL 14/01/23</i>			
150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat <i>Memo</i>	0.00 0.00	<i>N/A SHP</i>						
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>Memo</i> START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00	<i>paint @ ATG</i>			<i>CL 14/01/23</i>			



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Item ID: D2230-1 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Mounting Lug

Start Date: 1/7/2014 Start Qty: 200.00 *200*

Required Date: 2/21/2014 Req'd Qty: 200.00 *200*

Reference: Cust Item ID: Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

170

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

180

180

Packaging

Packaging

Identify as per dwg & Stock Location: ST 470 0.00

Memo

0.00

190

190

QC

Quality Control

QC21- Final Inspection - Work Order Release 0.00

Memo

0.00

80

80x

14-3-6

DAS
28
-88

14-03-7

14-03-07

Picklist Print

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Page 1

Work Order ID: 110834

Parent Item: D2230-1

Start Date: 1/7/2014

Required Date: 2/21/2014

Parent Item Name: Mounting Lug

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP D00.11.01 Added inspection level 8, and removed P/O for powder coat EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-1P Lug		Purchased	No				Each	0.0000		200		1/4/13/3	(80)
D2423 Lug Extrusion		Manufactured	No			110	f	308.9200	0.0683	15		1/2 1/10/123	

Location

Loc Qty

Loc Code

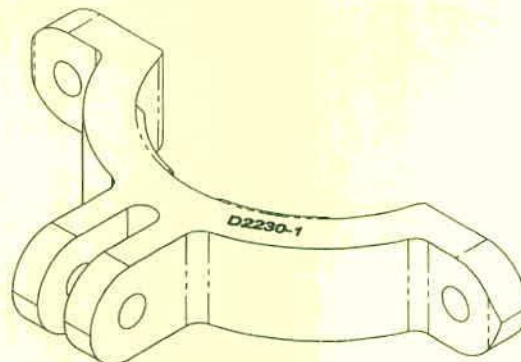
HALL

308.92

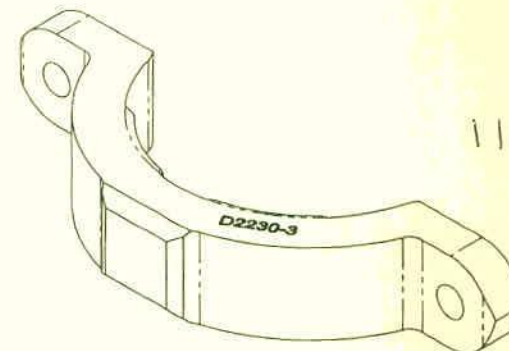
105422

308.92

15



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

110834 MJS
14-01-08

RELEASED
09/06/2016



NOTES:

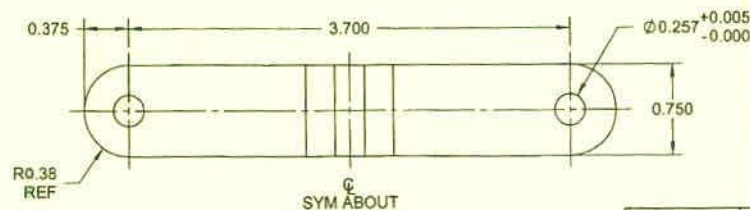
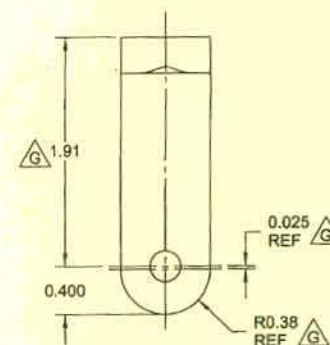
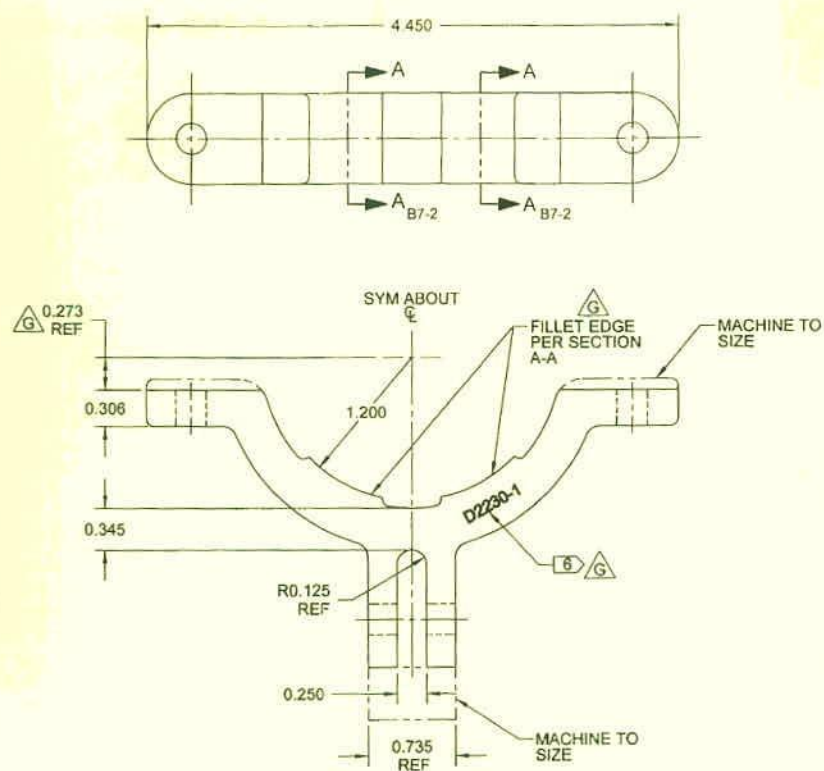
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010±0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015±0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2230	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED BY THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SECTION A-A D4-2
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-1 MOUNTING LUG

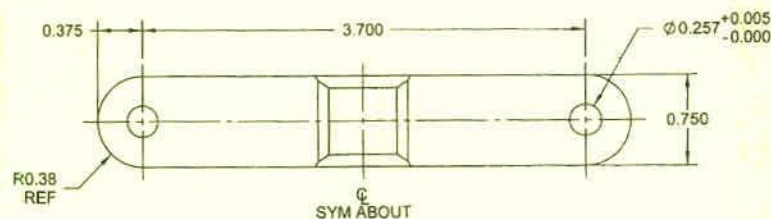
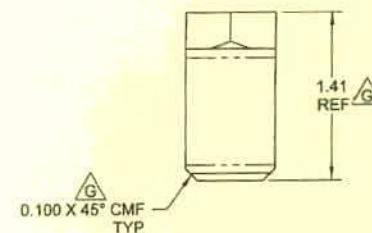
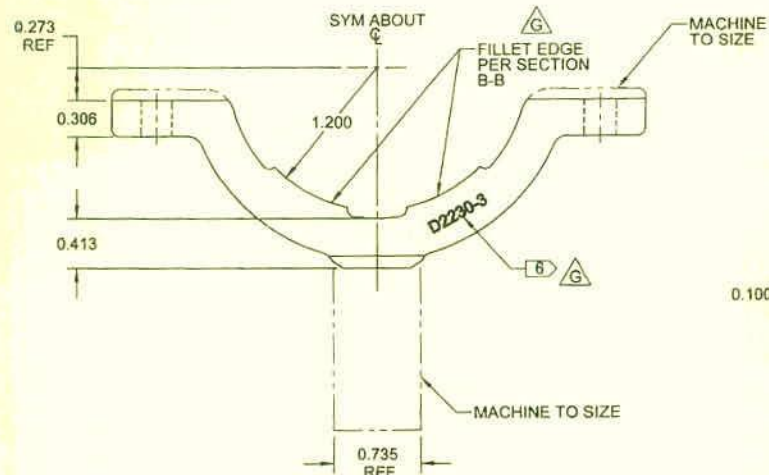
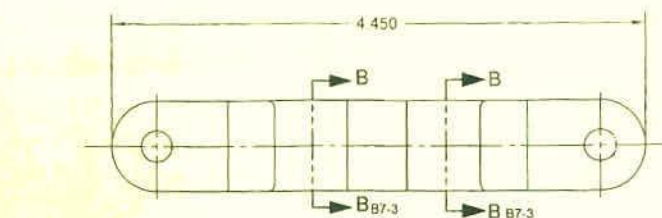
RELEASED
09/06/25/16

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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SECTION B-B
D4-3
SCALE 2X



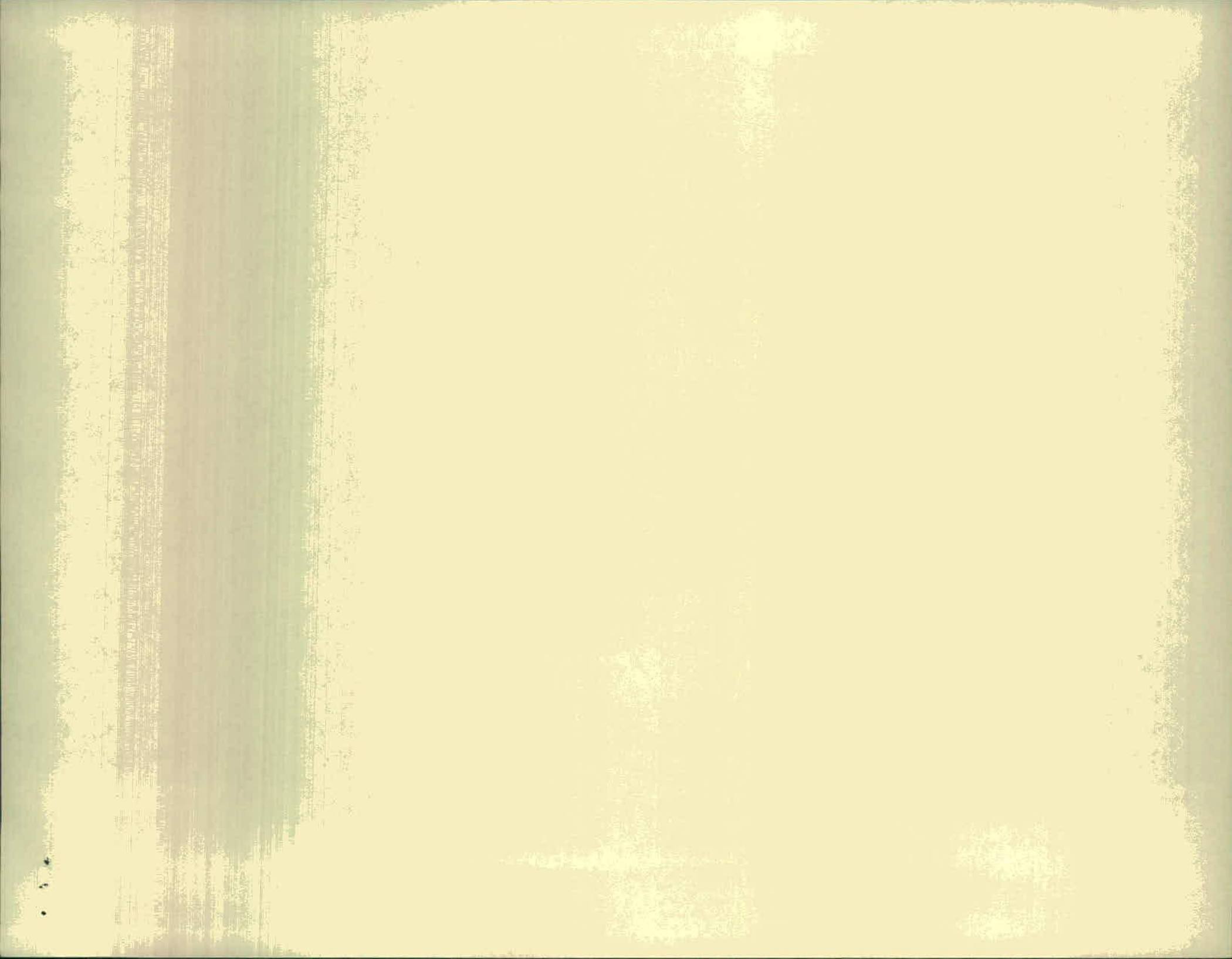
R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

RELEASED
09/06/25

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO22759

Purchase Order Date 1/23/2014

PO Print Date 1/23/2014

Page Number 1 of 1

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2230-1P	Lug	2/24/2014 Yes 2/24/2014		200.00 Each	\$12.00	\$2,400.00

NOTE

Manufacture as per drawing D2230-1.
Rev.G
B110834

F.A.I. required on first manufacture part. Production to proceed once approval has been given.

Neeso

Line Total: \$2,400.00

PO Total: \$2,400.00

PO Instructions:

NOTE

First Article Inspection required, full production to commence when approval has been given.

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.
No substitution or deviation without consent.

M. Eugene



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 907441

Date: 28-Feb-14

To

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ship To

CHANTAL LAVOIE
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.			
80 ea	Part: D2230-1P MOUNTING LUG Job: 15755	Rev: G Line: 1	PO: PO22759
DATE: 28 Feb 2014			
CERTIFIED SIGNATURE: <i>[Signature]</i>			
RECEIVER SIGNATURE: _____			
CERTIFICATE OF CONFORMANCE			
A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT ARE IN CONFORMANCE WITH THE REQUIREMENTS, SPECIFICATIONS, AND DRAWINGS REFERENCED IN THE ABOVE PURCHASE ORDER. I.S.O. 9001 : 2008 REGISTERED / MADE IN CANADA			

